

Work Order ID 66077

Thursday, February 03, 2011 3:07:45 PM



Page 1

Item ID: D3253-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Small Shelf

Start Date: 2/4/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 2/18/2011 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan: MUC Date: 11-02-03 Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3253	Rev A

100	PURCHASING	0.00							
	Waterjet								
	FLOW CNC Waterjet								
	2024 .063								
	Memo	0.00							
	Program rev: <u>A</u>								
	drawing rev: <u>A</u>								

B11-2-7

(4)

120	QC2- Inspect parts off machine FAI/FAIB	0.00							
	QC								
	Quality Control								
	Memo	0.00							

B11-2-7

140	QC8- Inspect parts - second check	0.00							
	QC								
	Quality Control								
	Memo	0.00							

Sulalos

(X4)

11.02.08 WC Brake bend as per dwg Sp. 11/02/08

QCS → Sulalos (X4)

(4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150



HandFinish

Chemical Conversion Coat per QSI005 4.1

0.00

Memo

0.00

Hand Finishing

4 0 11/02/09

160



Powdercoat

Black Sandtex(Ref:4.3.5.7) per QSI005 4.3

0.00

Memo

0.00

Powder Coating

START TIME:

8:30

OVEN TEMPERATURE:

FINISH TIME:

4:00

H BR 11-02-9

170



QC

QC3- Inspect Part Finish

0.00

Memo

0.00

Quality Control

11 4 0 11/02/09

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Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180



Packaging

Packaging

Identify as per dwg & Stock Location:

147

0.00

Memo

0.00

190



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

11/02/10 (4)

11/02/10

MF

11-02-10

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Picklist Print

Thursday, February 03, 2011 3:07:38 PM

Page 1

Work Order ID: 66077



Parent Item: D3253-1



Parent Item Name: Small Shelf

Start Date: 2/4/2011

Required Date: 2/18/2011

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP B 04.10.26 D3253-1 no longer made in-house

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M2024T3S.063

Purchased

No

sf

55.9270

5.184



2024-T3 .063 sheet

B 11-2-7

Location

Loc Qty

Loc Code

MAT22

55.927

114351

55.927

114351

(4)

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DART AEROSPACE LTD		Work Order: 606077
Description: Small Shelf (Dual Battery Rack)		Part Number: D3253-1
Inspection Dwg: D3253	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article
 ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
23.289	+/-0.010	23.289	X		T.H.01	
1.425	+/-0.010	1.421	X		V.B.02	
R0.19	+/-0.030	.19	X		R.G.	
0.697	+/-0.010	0.697	X		V	
6.502	+/-0.010	6.504	X		V	
5.200	+/-0.010	5.204	X		V	
1.300 Pitch	+/-0.010	1.304	X		V	
Ø0.098	+0.005/-0.000	.101	X		V	
0.300	+/-0.010	0.301	X		V	
R0.13	+/-0.030	.13	X		R.G.	
0.651	+/-0.010	0.653	X		V	
0.643	+/-0.010	0.640	X		V	
8.020	+/-0.010	8.021	X		PRO W3.02	
7.508	+/-0.010	7.505	X		V	
R0.13	+/-0.030	.13	X		R.G.	
0.063	+/-0.005	0.063	X		V	
Grain along 23.289	N/A		X			

Measured by: JB	Audited by: S	Prototype Approval:	N/A
Date: 11-2-7	Date: 11/2/08	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.07.07	New Issue P/O D205-579-015	KJ/JLM	[Signature]

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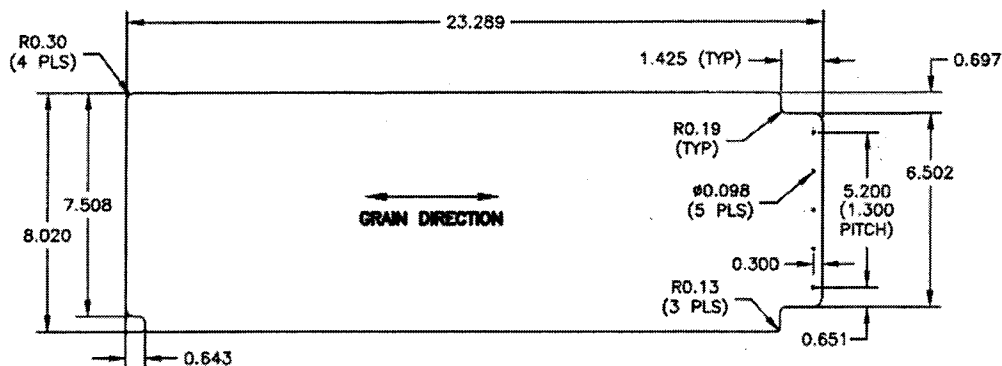
NOTE: Date & initial all entries



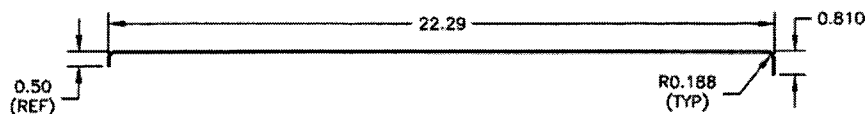
DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED CP	APPROVED [Signature]	DRAWING NO. D3253	REV. A SHEET 1 OF 1
DATE 04.04.06		TITLE SMALL SHELF (DUAL BATTERY RACK)	SCALE 1:6
A	04.04.06	NEW ISSUE	

RELEASED
04.05.04

#66077



FLAT PATTERN



D3253-1 BEND DETAIL

NOTES:

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) 0.063 THICK (REF. DART SPEC. M2024T3S.063)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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